



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3078-042
Job Sheet 203461



DAS
5 24
Job Qty: 4 pcs 9-89

Part No: D3078-042

Part Name: Step Assembly, Hi Short RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/20/19

Job Tracking No:

Due Date: 1/10/20

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG REV B IPP REV:A 15.10.21 NEW ISSUE DD VERF:JLM IPP REV:B 15.11.12 REV:C3 DD VERF:JLM
IPP REV:C 16.03.15 DWG REV,B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier		Sign-off
							Workcenter / Supplier	Lead Time	
110	Large Fab - Steps - 1	4 pcs	1/10/20		0.00	4.80	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
120	QC 5	4 pcs	1/10/20		0.00	0.00	QC 5 - 10		DAS JAN 02 2020 68 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		

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130 Large Fab - Welded Assy-2-B4B	4 pcs	1/10/20	0.00 4.80	QC 5 - 81	
				Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
				Large Fab - 11 - B4B (Various)	
				Large Fab - 12 - B4B	
140 QC 9	4 pcs	1/10/20	0.00 0.00	QC 9 - 10	
				QC 9 - 18	
				QC 9 - 24	
				QC 9 - 43	
				QC 9 - 50	
				QC 9 - 9	
150 QC 5	4 pcs	1/10/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
160 Handfinish - 1-1 Chemical-B4B	4 pcs	1/10/20	0.00 0.83	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	

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				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
170 QC 7	4 pcs	1/10/20	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	AS
				QC 7 - 61	13
				QC 7 - 81	89
				QC 7 - 76	
				QC 7 - 79	
200 Large Fab - Welded Assy-3-B4B	4 pcs	1/10/20	0.00 4.80	Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	SL
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	ML, MR
				Large Fab - 11 - B4B (Various)	
				Large Fab - 12 - B4B	
210 QC 10	4 pcs	1/10/20	0.00 0.00	QC 10 - 10	
				QC 10 - 18	DAS
				QC 10 - 24	24
				QC 10 - 43	9-89
				QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
				QC 10 - 68	
220 QC 5	4 pcs	1/10/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	

				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	DAS
				QC 5 - 43	24
				QC 5 - 49	9-89
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
230	Handfinish - 6-1- Touch Up- B4B	4 pcs	1/10/20	0.00 0.83	Handfinish - 6 - 1 - B4B
					Handfinish - 6 - 2 - B4B
					Handfinish - 6 - 3 - B4B
					Handfinish - 6 - 4 - B4B
					Handfinish - 6 - 5 - B4B
					Handfinish - 6 - 6 - B4B
					Handfinish - 6 - 7 - B4B
					Handfinish - 6 - 8 - B4B
					Handfinish - 6 - 9 - B4B
					Handfinish - 6 - 10 - B4B
					Handfinish - 6 - 11 - B4B
					Handfinish - 6 - 12 - B4B
					Handfinish - 6 - 13 - B4B
					Handfinish - 6 - 14 - B4B
					Handfinish - 6 - 15 - B4B
					Handfinish - 6 - 16 - B4B
					Handfinish - 6 - 17 - B4B
					Handfinish - 6 - 18 - B4B
					Handfinish - 6 - 19 - B4B
					Handfinish - 6 - 20 - B4B
					Handfinish - 6 - 21 - B4B
					Handfinish - 6 - 22 - B4B
240	Powdercoat - 1 White Gl(A)- B4B	4 pcs	1/10/20	0.00 0.76	Powdercoat - 1 - B4B
					Powdercoat - 2 - B4B
					Powdercoat - 3 - B4B
					Powdercoat - 4 - B4B
250	Handfinish - 3-1- WingWalk- B4B	4 pcs	1/10/20	0.00 0.50	Handfinish - 3 - 1 - B4B
					Handfinish - 3 - 2 - B4B
					Handfinish - 3 - 3 - B4B
					Handfinish - 3 - 4 - B4B
					Handfinish - 3 - 5 - B4B
260	QC 3	4 pcs	1/10/20	0.00 0.00	QC 3 - 10
					QC 3 - 13
					QC 3 - 15
					QC 3 - 17
					QC 3 - 18
					QC 3 - 2
					QC 3 - 28
					QC 3 - 3
					QC 3 - 30
					QC 3 - 34
					QC 3 - 36
					QC 3 - 41
					QC 3 - 51

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					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
290	Packaging 3-1 - Stock - B4B	4 pcs	1/10/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
300	QC 21 - SA	4 pcs	1/10/20	0.00 0.00	QC 21 - SA - 21	JAN 28 2020
					QC 21 - SA - 70	21
					QC 21 - SA - 53	21

Part Op 110 - (Fabricate per Drwg) 1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078 2-Drill extrusion as per Dwg
 Descriptions: D3078 using Jig DT8680 for rivets. 3-Debur
 120 - QC5- Inspect part completeness to step on W/O
 130 - (Weld per dwg A/R Aluminum rod Batch: _____) 1-Bevel end for welding FWD ONLY 2-Weld Support, weld Fwd
 End Plate as per QSI 004 & Dwg D3078 A/R Aluminum Rod _____ 3-Grind End Plate flush
 140 - (QC9- Inspect visual per QSI004- Fusion Welds)
 150 - (QC5- Inspect part completeness to step on W/O)
 160 - (Chemical Conversion Coat per QSI005 4.1)
 170 - (QC7-Inspect Chemical Conversion Coat)
 200 - (Weld per dwg A/R Aluminum rod Batch: _____) 1- Rivet Leg Assembly as per Dwg D3078. 2-Bevel Aft end for
 welding 3-Inspect for foreign object as per QSI 024 4-Weld Aft End Plate as per QSI 004 & Dwg D3078 A/R Aluminum
 Rod _____ 5-Grind End Plate flush

210 - (QC10- Inspect visual per QSI004- ground welds)

220 - (QC5- Inspect part completeness to step on W/O)

230 - (Touch up alodine)

240 - (White Gloss (Ref 4.3.5.1) per QSI005 4.3-Alum) START TIME: 1:05 OVEN TEMPERATURE: 320FINISH TIME: 1:35250 - (Wing Walk as per dwg QSI005 4.4 Batch 5240464)

260 - (QC3- Inspect Part Finish)

290 - Identify as per dwg & Stock Location: _____

300 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	2 pcs (.5 ea)	110-Large Fab - Steps - 1	<u>5293008</u>
D3067-1	End Plate	8 pcs (2 ea)	130-Large Fab - Welded Assy-2- B4B	<u>5229649</u>
D3219-3	Plate	8 pcs (2 ea)	130-Large Fab - Welded Assy-2- B4B	<u>5207480</u>
D3065-041	Step Leg Assembly	4 pcs (1 ea)	200-Large Fab - Welded Assy-3- B4B	<u>5242734</u>
D3066-1	Spacer	8 pcs (2 ea)	200-Large Fab - Welded Assy-3- B4B	<u>5223156</u>
MS20600-AD4W4	Rivet	64 Ea (16 ea)	200-Large Fab - Welded Assy-3- B4B	<u>5234250/5239745</u> (35)

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Steps - 1	D2622-120C	2	65	0
130-Large Fab - Welded Assy-2- B4B	D3067-1	8	126	0
	D3219-3	8	90	0
200-Large Fab - Welded Assy-3- B4B	D3065-041	4	8	0
	D3066-1	8	195	0
	MS20600-AD4W4	64	295	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :	MRB (QSI042)		
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S243649



Part: D3078-042

Job No: 203461

Serial No/Batch: S243649

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

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